

**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø h7: 11,8 mm****Order data**

Order number	123302 11,8
GTIN	4045197459367
Item class	11E

Description**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Recommendation:**Maximum drilling depth:**

clamping slot length (see table) less 1.5×nominal Ø.

Note:

For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068– 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123226 and 123236.

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 156 mm

Overall length L_{tot} : 204 mm

Shank Ø: 12 mm

Feed f in steel < 1100 N/mm²: 0.2 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.2 mm/rev.
Nominal Ø	11.8 mm
Shank tolerance	h6
Number of cutting edges Z	2
Flute length	156 mm
Tolerance nominal Ø	h7
Shank Ø	12 mm
Overall length L _{tot}	204 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	138.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Skaft	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Pilot drill required	yes, pilot drill
Colour ring	green